



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

K10111

Job Sheet 181007



Part No: K10111

Job Qty: 1 ea

Part Name: Saddle, Skidtube 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 7/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG DSI 9583 REV A, K10111 REV C IPP : F 01.11.08 Revised Step 5 and Added Inspection Level 21 SM
IPP REV:G 11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14 AS PER DSI9583 DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Stores/Pkg-2		
110	Packaging	1 pcs	7/31/18	7/31/18	0.00	0.00	Packaging1-5		JUL 26 2018
120	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC4		BB
125	DC	1 pcs	7/31/18	7/31/18	0.00	0.00	DC		BB
130	Packaging	1 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3-2		BB
140	QC21-SA	1 Ea	7/31/18	7/31/18	0.00	0.00	QC21		JUL 30 2018

Part Op 125 - Photocopy bluefile & type labels per PPP K10111 CHG005 FOR D206-642-111 CHG005 FOR D206-642-113
Descriptions: CHG005

130 - Identify and pack for shipping as per PPP K10111 PPP D206-642-111 PPP D206-642-113 Location: _____

PPP rev: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S095673



Part: K10111

Job No: 181007

Serial No/Batch: S095673

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/24/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	5038750
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5058782
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	509407
AN5-10A	Bolt	4 Ea (4 ea)	90-Start up Operation	5014015
AN5-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	503527
AN6-44A	Bolt	2 Ea (2 ea)	90-Start up Operation	50123265
D206-651-041	206 A/B Ground Handling Wheel	1 Ea (1 ea)	90-Start up Operation	5095823
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	5054624
D2661-1	Saddle, LH, Fwd, Aft, Out	2 Ea (2 ea)	90-Start up Operation	5160726
D2662-1	Saddle, LH Fwd, Aft, In	2 Ea (2 ea)	90-Start up Operation	5160826
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5022936
D2884	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5054580
D2885	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5068098
D3413-1	O-Ring	1 Ea (1 ea)	90-Start up Operation	5078167
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	5081365
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5067266
MS21042L6	Nut	2 Ea (2 ea)	90-Start up Operation	5033753
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation	5015267
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	5062319
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	506802
NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation	5043782
NAS1149D0663J	Washer	4 Ea (4 ea)	90-Start up Operation	

5031303

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	163	0
	AN4-6A	12	1,619	0
	AN4C5A	1	63	0
	AN5-10A	4	207	0
	AN5-11A	4	135	0
	AN6-44A	2	130	0
	D206-651-041	1	1	0
	D2652	16	495	0
	D2661-1	2	6	0
	D2662-1	2	5	0
	D2712	10	635	0
	D2884	2	20	0
	D2885	2	30	0
	D3413-1	1	38	0
	MS21042L3	8	1,723	0
	MS21042L4	12	3,494	0
	MS21042L6	2	238	0
	NAS1149C0463R	1	181	0
	NAS1149D0363J	8	1,279	0
	NAS1149D0463J	24	11,486	0
	NAS1149D0563J	8	1,311	0
	NAS1149D0663J	4	483	0

Part Specifications

Specifications could not be found.

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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OTHER : ☐					

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>E</i>	K10111	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

Change Record

Part Number K10111Page 1 of 1

Description SADDLE KIT FOR D206-642-111/-113

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